



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4072-5

Job Sheet 170284



Part No: D4072-5

Job Qty: 12 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/26/18

Type: Stock

Description:

Note: DWG REV B SHEET 3 IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED BY:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		1/25/18	0.00	0.00	Start Up Machining-2		18-1-30
100	Hardinge	12 pcs		1/26/18	0.03	0.84	Hardinge		18-1-30
120	QC	12 pcs		1/26/18	0.00	0.00	QC8		18-01-31
130	Packaging	12 pcs		1/26/18	0.00	0.00	Packaging3-2		521
140	QC21-SA	12 Ea		1/26/18	0.00	0.00	QC21		18-02-01

Part Op Descriptions: 100 - 1-Turn as per Dwg and Folio FA978

DAS
21
9-89

FEB 01 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.500	0	77	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.450Inches ± 0.030	0.480 0.420	.450	Diameter
2	Bushing	0.196Inches + 0.005 - 0.001	0.201 0.195	.196	Diameter
3	Bushing	0.313Inches ± 0.010	0.323 0.303	.313	Diameter
4	Bushing	0.020Inches ± 0.100	0.120 (0.080)	.020	
5	Bushing	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
6	Bushing	0.230Inches + 0.015 - 0.000	0.245 0.230	.231	
7	Bushing	0.010Inches ± 0.030	0.040 (0.020)	.015	Radius
8	Bushing	0.060Inches + 0.000 - 0.015	0.060 0.045	.051	

QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		SI M: Thermo Le		AGAINST DEPARTMENT/PROCESS PART NO: D4072-5 Original Serial #: S037079 Revision: Operation: Change No:  S037079 Start up Operation 01/30/18 Job No: 170284  S037079																																																																																																			
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